



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2571

Job Sheet 170024



Part No: D2571

Job Qty: 6 ea

Part Name: Saddle, Fwd, Out



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/8/18

Job Tracking No:

Due Date: 1/18/18

Created By: Mario Poulin

Type: SOLD

Description:

Note: DWG REV F IPP: 1 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572 KJ

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea	1/17/18	1/17/18	0.00	0.00	Start Up Machining		B. SBL 18/01/30
100	CNC Vertical Machining	6 pcs	1/17/18	1/17/18	0.57	9.68	HAAS 1		B. SBL 18/01/31
110	Mill Conv	6 pcs	1/17/18	1/17/18	0.00	0.92	Mill Conv 1		B. FK 18-2-2
120	QC	6 pcs	1/17/18	1/17/18	0.00	0.00	QC2		B. FK 18-2-2
130	QC	6 pcs	1/17/18	1/17/18	0.00	0.00	QC8		B. FK 18-2-2
140	HandFinish	6 pcs	1/17/18	1/17/18	0.00	0.20	HandFinish1		B. 18-02-12
150	Powdercoat	6 pcs	1/18/18	1/18/18	0.00	0.24	Powdercoat1		B. 18-02-13
160	QC	6 pcs	1/18/18	1/18/18	0.00	0.00	QC3		B. 18-02-13
170	Packaging	6 pcs	1/18/18	1/18/18	0.00	0.00	Packaging3		B. 18-02-13
180	QC21-SA	6 Ea	1/18/18	1/18/18	0.00	0.00	QC21		B. 18-02-13

Part Op 100 - Program Batch No. _____ Double check by: _____ 1-Machine Step No 1 per Folio FA051 and inspect per Descriptions: attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect
110 - Machine keyway as per dwg D2571 & D2572
120 - Inspect on CMM as per folio CMM022.
150 - START TIME: 12:00 FINISH TIME: 12:30 ON F: 300 M 188467.

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D6101-007	6	16	0	0
F165288 -> S036733					

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Saddle, Fwd Outboard	0.438Inches + 0.005 - 0.000	0.443 0.438		
2	Saddle, Fwd Outboard	1.745Inches + 0.010 - 0.000	1.755 1.745		
3	Saddle, Fwd Outboard	3.495Inches + 0.010 - 0.000	3.505 3.495		
4	Saddle, Fwd Outboard	1.745Inches + 0.010 - 0.000	1.755 1.745		
5	Saddle, Fwd Outboard	7.990Inches + 0.020 - 0.000	8.010 7.990		
6	Saddle, Fwd Outboard	0.490Inches	0.510		

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Water Jet ☐ Engineering ☐ Machinin _____ Thermoformin _____ Large Fa _____																																																													
Date : _____		Step #: _____		QTY Eff _____																																																													
Description Work Order Deviation Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K64 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com																																																																	
Root Cause <table style="width:100%; border-collapse: collapse;"> <tr> <td style="width: 33%;">Environment ☐</td> <td style="width: 33%;">No Re-verification ☐</td> <td style="width: 33%;">Pressure/Forced ☐</td> </tr> <tr> <td>Design ☐</td> <td>Operator ☐</td> <td>Bending ☐</td> </tr> <tr> <td>Doc/Data ☐</td> <td>Offset/Setup ☐</td> <td>Centre Not Concentric ☐</td> </tr> <tr> <td>Equip/Tooling ☐</td> <td>Supplier ☐</td> <td>Cracks ☐</td> </tr> <tr> <td>Handling/Pre ☐</td> <td>Training ☐</td> <td>Crimp/Kink/Ripple/Wave ☐</td> </tr> <tr> <td>Material ☐</td> <td>Use for Testing ☐</td> <td>Cuffs ☐</td> </tr> <tr> <td>Internal Transport ☐</td> <td>Poor Information ☐</td> <td>Crushing ☐</td> </tr> <tr> <td>Tribal Knowledge ☐</td> <td>Rushing ☐</td> <td>Heat Treat ☐</td> </tr> <tr> <td>LOA ☐</td> <td>Product Improvement ☐</td> <td>Wave/Twist in Tube ☐</td> </tr> <tr> <td>Substation ☐</td> <td>Process Improvement ☐</td> <td>Marks/Chatter ☐</td> </tr> <tr> <td>Past Expiry Date ☐</td> <td>Manufacturing Process ☐</td> <td>Temperature/Cu ☐</td> </tr> <tr> <td>Misidentified ☐</td> <td>Past Due ☐</td> <td>Set-up ☐</td> </tr> <tr> <td></td> <td></td> <td>BOM/Route ☐</td> </tr> <tr> <td></td> <td></td> <td>Broken/Damage ☐</td> </tr> <tr> <td></td> <td></td> <td>Inspection Incon ☐</td> </tr> <tr> <td></td> <td></td> <td>Contamination ☐</td> </tr> <tr> <td></td> <td></td> <td>Countersink ☐</td> </tr> <tr> <td></td> <td></td> <td>Cut Too Short ☐</td> </tr> <tr> <td></td> <td></td> <td>Instructions Incc ☐</td> </tr> <tr> <td></td> <td></td> <td>Drill Holes ☐</td> </tr> </table> Saddle, Fwd, Out						Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Design ☐	Operator ☐	Bending ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Past Expiry Date ☐	Manufacturing Process ☐	Temperature/Cu ☐	Misidentified ☐	Past Due ☐	Set-up ☐			BOM/Route ☐			Broken/Damage ☐			Inspection Incon ☐			Contamination ☐			Countersink ☐			Cut Too Short ☐			Instructions Incc ☐			Drill Holes ☐
Environment ☐	No Re-verification ☐	Pressure/Forced ☐																																																															
Design ☐	Operator ☐	Bending ☐																																																															
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐																																																															
Equip/Tooling ☐	Supplier ☐	Cracks ☐																																																															
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐																																																															
Material ☐	Use for Testing ☐	Cuffs ☐																																																															
Internal Transport ☐	Poor Information ☐	Crushing ☐																																																															
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐																																																															
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐																																																															
Substation ☐	Process Improvement ☐	Marks/Chatter ☐																																																															
Past Expiry Date ☐	Manufacturing Process ☐	Temperature/Cu ☐																																																															
Misidentified ☐	Past Due ☐	Set-up ☐																																																															
		BOM/Route ☐																																																															
		Broken/Damage ☐																																																															
		Inspection Incon ☐																																																															
		Contamination ☐																																																															
		Countersink ☐																																																															
		Cut Too Short ☐																																																															
		Instructions Incc ☐																																																															
		Drill Holes ☐																																																															

DART
AEROSPACE
S036736



Saddle, Fwd, Out

PART NO: D2571
Original Serial #: S036736
Revision:
Operation: Start up Operation 01/30/18
Change No: Job No: 170024

Approval _____
 By _____
 Supervisor _____
 Initiator _____
 Ironing _____
 Extensions _____
 tolerance _____
 it _____
 ssing _____
 jence _____

			+ 0.020	0.490
			- 0.000	
7	Saddle, Fwd Outboard	0.257Inches	+ 0.005 - 0.000	0.262 0.257
8	Saddle, Fwd Outboard	0.375Inches	+ 0.005 - 0.000	0.380 0.375
9	Saddle, Fwd Outboard	0.490Inches	+ 0.020 - 0.000	0.510 0.490
10	Saddle, Fwd Outboard	1.174Inches	+ 0.010 - 0.000	1.184 1.174
11	Saddle, Fwd Outboard	0.558Inches	+ 0.020 - 0.000	0.578 0.558
12	Saddle, Fwd Outboard	1.174Inches	+ 0.010 - 0.000	1.184 1.174
13	Saddle, Fwd Outboard	1.490Inches	+ 0.010 - 0.000	1.500 1.490
14	Saddle, Fwd Outboard	2.495Inches	+ 0.010 - 0.000	2.505 2.495
15	Saddle, Fwd Outboard	3.869Inches	+ 0.010 - 0.000	3.879 3.869
16	Saddle, Fwd Outboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
17	Saddle, Fwd Outboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
18	Saddle, Fwd Outboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
19	Saddle, Fwd Outboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
20	Saddle, Fwd Outboard	0.178Inches	+ 0.020 - 0.000	0.198 0.178
21	Saddle, Fwd Outboard	2.940Inches	+ 0.040 - 0.000	2.980 2.940
22	Saddle, Fwd Outboard	0.230Inches	+ 0.020 - 0.000	0.250 0.230
23	Saddle, Fwd Outboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
24	Saddle, Fwd Outboard	0.308Inches	+ 0.005 - 0.000	0.313 0.308
25	Saddle, Fwd Outboard	0.760Inches	+ 0.005 - 0.000	0.765 0.760
26	Saddle, Fwd Outboard	0.352Inches	+ 0.020 - 0.000	0.372 0.352
27	Saddle, Fwd Outboard	0.470Inches	+ 0.060 - 0.000	0.530 0.470
28	Saddle, Fwd Outboard,	0.615Inches	+ 0.020 - 0.000	0.635 0.615
29	Saddle, Fwd Outboard	0.053Inches	+ 0.020 - 0.000	0.073 0.053
30	Saddle, Fwd Outboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
31	Saddle, Fwd Outboard	1.375Inches	+ 0.020 - 0.000	1.395 1.375
32	Saddle, Fwd Outboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
33	Saddle, Fwd Outboard	0.240Inches	+ 0.040 - 0.000	0.280 0.240
34	Saddle, Fwd Outboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
35	Saddle, Fwd Outboard	2.000Inches	+ 0.020 - 0.000	2.020 2.000
36	Saddle, Fwd Outboard	0.023Inches	+ 0.020 - 0.000	0.043 0.023

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																																																																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																																																																						
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																																																																						
Large Fab ☐	Composite ☐	Supplier ☐																																																																							
Date: _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval																																																																		
Description Work Order Deviation				Disposition				Completed By																																																																	
Root Cause				FAULT CATEGORY																																																																					
<table style="width: 100%; border: none;"> <tr><td style="border: none;">Environment ☐</td><td style="border: none;">No Re-verification ☐</td></tr> <tr><td style="border: none;">Design ☐</td><td style="border: none;">Operator ☐</td></tr> <tr><td style="border: none;">Doc/Data ☐</td><td style="border: none;">Offset/Setup ☐</td></tr> <tr><td style="border: none;">Equip/Tooling ☐</td><td style="border: none;">Supplier ☐</td></tr> <tr><td style="border: none;">Handling/Pre ☐</td><td style="border: none;">Training ☐</td></tr> <tr><td style="border: none;">Material ☐</td><td style="border: none;">Use for Testing ☐</td></tr> <tr><td style="border: none;">Internal Transport ☐</td><td style="border: none;">Poor Information ☐</td></tr> <tr><td style="border: none;">Tribal Knowledge ☐</td><td style="border: none;">Rushing ☐</td></tr> <tr><td style="border: none;">LOA ☐</td><td style="border: none;">Product Improvement ☐</td></tr> <tr><td style="border: none;">Substation ☐</td><td style="border: none;">Process Improvement ☐</td></tr> <tr><td style="border: none;">Past Expiry Date ☐</td><td style="border: none;">Manufacturing Process ☐</td></tr> <tr><td style="border: none;">Misidentified ☐</td><td style="border: none;">Past Due ☐</td></tr> </table>		Environment ☐	No Re-verification ☐	Design ☐	Operator ☐	Doc/Data ☐	Offset/Setup ☐	Equip/Tooling ☐	Supplier ☐	Handling/Pre ☐	Training ☐	Material ☐	Use for Testing ☐	Internal Transport ☐	Poor Information ☐	Tribal Knowledge ☐	Rushing ☐	LOA ☐	Product Improvement ☐	Substation ☐	Process Improvement ☐	Past Expiry Date ☐	Manufacturing Process ☐	Misidentified ☐	Past Due ☐	<table style="width: 100%; border: none;"> <tr><td style="border: none;">Pressure/Forced ☐</td></tr> <tr><td style="border: none;">Bending ☐</td></tr> <tr><td style="border: none;">Centre Not Concentric ☐</td></tr> <tr><td style="border: none;">Cracks ☐</td></tr> <tr><td style="border: none;">Crimp/Kink/Ripple/Wave ☐</td></tr> <tr><td style="border: none;">Cuffs ☐</td></tr> <tr><td style="border: none;">Crushing ☐</td></tr> <tr><td style="border: none;">Heat Treat ☐</td></tr> <tr><td style="border: none;">Wave/Twist in Tube ☐</td></tr> <tr><td style="border: none;">Marks/Chatter ☐</td></tr> </table>		Pressure/Forced ☐	Bending ☐	Centre Not Concentric ☐	Cracks ☐	Crimp/Kink/Ripple/Wave ☐	Cuffs ☐	Crushing ☐	Heat Treat ☐	Wave/Twist in Tube ☐	Marks/Chatter ☐	<table style="width: 100%; border: none;"> <tr><td style="border: none;">Temperature/Cure ☐</td></tr> <tr><td style="border: none;">Set-up ☐</td></tr> <tr><td style="border: none;">BOM/Route ☐</td></tr> <tr><td style="border: none;">Broken/Damage/Defect ☐</td></tr> <tr><td style="border: none;">Inspection Incomplete/Unqualified ☐</td></tr> <tr><td style="border: none;">Contamination ☐</td></tr> <tr><td style="border: none;">Countersink ☐</td></tr> <tr><td style="border: none;">Cut Too Short ☐</td></tr> <tr><td style="border: none;">Instructions Incomplete/Unclear ☐</td></tr> <tr><td style="border: none;">Drill Holes ☐</td></tr> </table>		Temperature/Cure ☐	Set-up ☐	BOM/Route ☐	Broken/Damage/Defect ☐	Inspection Incomplete/Unqualified ☐	Contamination ☐	Countersink ☐	Cut Too Short ☐	Instructions Incomplete/Unclear ☐	Drill Holes ☐	<table style="width: 100%; border: none;"> <tr><td style="border: none;">Power Loss/Surge ☐</td></tr> <tr><td style="border: none;">Folio/Program ☐</td></tr> <tr><td style="border: none;">Grain ☐</td></tr> <tr><td style="border: none;">Weld ☐</td></tr> <tr><td style="border: none;">Wrong Stock Pulled ☐</td></tr> <tr><td style="border: none;">Out of Sequence ☐</td></tr> <tr><td style="border: none;">Off-set ☐</td></tr> <tr><td style="border: none;">Mislabeled ☐</td></tr> <tr><td style="border: none;">Fit/Function ☐</td></tr> <tr><td style="border: none;">Misaligned/off center ☐</td></tr> </table>		Power Loss/Surge ☐	Folio/Program ☐	Grain ☐	Weld ☐	Wrong Stock Pulled ☐	Out of Sequence ☐	Off-set ☐	Mislabeled ☐	Fit/Function ☐	Misaligned/off center ☐	<table style="width: 100%; border: none;"> <tr><td style="border: none;">Positioned Wrong ☐</td></tr> <tr><td style="border: none;">Outside Dimensions ☐</td></tr> <tr><td style="border: none;">Over/Under tolerance ☐</td></tr> <tr><td style="border: none;">Part Incorrect ☐</td></tr> <tr><td style="border: none;">Part Lost/Missing ☐</td></tr> <tr><td style="border: none;">Part Moved ☐</td></tr> <tr><td style="border: none;">Drawing ☐</td></tr> <tr><td style="border: none;">Finish ☐</td></tr> <tr><td style="border: none;">Misread ☐</td></tr> <tr><td style="border: none;">Turning Sequence ☐</td></tr> </table>		Positioned Wrong ☐	Outside Dimensions ☐	Over/Under tolerance ☐	Part Incorrect ☐	Part Lost/Missing ☐	Part Moved ☐	Drawing ☐	Finish ☐	Misread ☐	Turning Sequence ☐
Environment ☐	No Re-verification ☐																																																																								
Design ☐	Operator ☐																																																																								
Doc/Data ☐	Offset/Setup ☐																																																																								
Equip/Tooling ☐	Supplier ☐																																																																								
Handling/Pre ☐	Training ☐																																																																								
Material ☐	Use for Testing ☐																																																																								
Internal Transport ☐	Poor Information ☐																																																																								
Tribal Knowledge ☐	Rushing ☐																																																																								
LOA ☐	Product Improvement ☐																																																																								
Substation ☐	Process Improvement ☐																																																																								
Past Expiry Date ☐	Manufacturing Process ☐																																																																								
Misidentified ☐	Past Due ☐																																																																								
Pressure/Forced ☐																																																																									
Bending ☐																																																																									
Centre Not Concentric ☐																																																																									
Cracks ☐																																																																									
Crimp/Kink/Ripple/Wave ☐																																																																									
Cuffs ☐																																																																									
Crushing ☐																																																																									
Heat Treat ☐																																																																									
Wave/Twist in Tube ☐																																																																									
Marks/Chatter ☐																																																																									
Temperature/Cure ☐																																																																									
Set-up ☐																																																																									
BOM/Route ☐																																																																									
Broken/Damage/Defect ☐																																																																									
Inspection Incomplete/Unqualified ☐																																																																									
Contamination ☐																																																																									
Countersink ☐																																																																									
Cut Too Short ☐																																																																									
Instructions Incomplete/Unclear ☐																																																																									
Drill Holes ☐																																																																									
Power Loss/Surge ☐																																																																									
Folio/Program ☐																																																																									
Grain ☐																																																																									
Weld ☐																																																																									
Wrong Stock Pulled ☐																																																																									
Out of Sequence ☐																																																																									
Off-set ☐																																																																									
Mislabeled ☐																																																																									
Fit/Function ☐																																																																									
Misaligned/off center ☐																																																																									
Positioned Wrong ☐																																																																									
Outside Dimensions ☐																																																																									
Over/Under tolerance ☐																																																																									
Part Incorrect ☐																																																																									
Part Lost/Missing ☐																																																																									
Part Moved ☐																																																																									
Drawing ☐																																																																									
Finish ☐																																																																									
Misread ☐																																																																									
Turning Sequence ☐																																																																									
OTHER : _____																																																																									

DART AEROSPACE LTD	Work Order: 170024
Description: Saddle, Fwd Outboard	Part Number: D2571
Inspection Dwg: D2571 Rev. F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.749	1.750	1.750	1.750		
C	3.495	3.505		3.498	3.500	3.498	3.500		
D	1.745	1.755		1.749	1.750	1.750	1.750		
E	7.990	8.010		8.002	8.000	8.001	8.001		
F	0.490	0.510		.500	.500	.500	.500		
G	0.257	0.262		.258	.258	.258	.258		
H	0.375	0.380		.377	.377	.377	.377		
I	0.490	0.510		.500	.500	.502	.502		
J	1.174	1.184		1.178	1.179	1.179	1.179		
K	0.558	0.578		.568	.559	.569	.570		
L	1.174	1.184		1.178	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.494	1.496	1.496		
N	2.495	2.505		2.498	2.499	2.499	2.499		
O	3.869	3.879		3.874	3.873	3.874	3.874		
P	0.115	0.135		.130	.130	.130	.130		
Q	0.115	0.135		.125	.125	.125	.125		
R	0.240	0.260		.252	.252	.252	.253		
S	0.115	0.135		.127	.126	.125	.128		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		.240	.240	.240	.240		
W	0.115	0.135		.121	.119	.120	.117		
X	0.308	0.313		.310	.310	.310	.310		
Y	0.760	0.765		.762	.760	.762	.760		
Z	0.352	0.372		.363	.364	.363	.366		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.626	.626	.626	.627		
AC	0.053	0.073		.068	.065	.065	.063		
AD	0.240	0.260		.249	.250	.249	.250		
AE	1.375	1.395		1.385	1.388	1.387	1.387		
AF	0.115	0.135		.130	.130	.130	.130		
AG	0.240	0.280		.255	.250	.260	.265		
AH	0.240	0.260		.250	.251	.248	.250		
AI	2.000	2.020		2.000	2.003	2.002	2.002		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by: SBL / E.K.	Audited by: [Signature]
Date: 18/01/30 / 18-2-1	Date: 18/02/12

Rev	Date	Change	Revised by	Approved
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

DART AEROSPACE LTD	Work Order: 170024
Description: Saddle, Fwd Outboard	Part Number: D2571
Inspection Dwg: D2571 Rev. F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	5	6	3	4		
A	0.438	0.443		.439	.439				
B	1.745	1.755		1.750	1.750				
C	3.495	3.505		3.500	3.500				
D	1.745	1.755		1.750	1.750				
E	7.990	8.010		8.000	8.000				
F	0.490	0.510		.498	.501				
G	0.257	0.262		.258	.258				
H	0.375	0.380		.377	.375				
I	0.490	0.510		.500	.504				
J	1.174	1.184		1.179	1.179				
K	0.558	0.578		.569	.571				
L	1.174	1.184		1.179	1.179				
M	1.490	1.500		1.498	1.495				
N	2.495	2.505		2.500	2.500				
O	3.869	3.879		3.874	3.874				
P	0.115	0.135		.130	.130				
Q	0.115	0.135		.125	.126				
R	0.240	0.260		.252	.251				
S	0.115	0.135		.125	.126				
T	0.178	0.198		.188	.188				
U	2.940	2.980		2.960	2.960				
V	0.230	0.250		.239	.239				
W	0.115	0.135		.119	.116				
X	0.308	0.313		.311	.310				
Y	0.760	0.765		.760	.760				
Z	0.352	0.372		.366	.366				
AA	0.470	0.530		.500	.500				
AB	0.615	0.635		.625	.625				
AC	0.053	0.073		.063	.063				
AD	0.240	0.260		.250	.249				
AE	1.375	1.395		1.385	1.385				
AF	0.115	0.135		.135	.135				
AG	0.240	0.280		.265	.265				
AH	0.240	0.260		.250	.250				
AI	2.000	2.020		2.000	2.000				
AJ	0.023	0.043		.033	.033				
Accept/Reject									

Measured by: SBL / FK	Audited by: [Signature]
Date: 18/01/30 / 18-2-1	Date: 18/02/12

Rev	Date	Change	Revised by	Approved
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	[Signature]